

03—015 Refacing crankcase parting surface

Data

Height of crankcase as new		242.9–242.8
Minimum height after necessary stock removal		242.5
Permissible irregularity of parting surface	lengthwise	0.10
	crosswise	0.05
Permissible roughness of upper parting surface		0.006–0.016
Permissible parallel misalignment of upper to lower parting surfaces in lengthwise direction		0.1
Air testing pressure in water at bar positive		1.4
Cylinder bore chamber		see note
Gap between piston crown and crankcase parting surface	Engines 615.913/940	+0.65 to +1.05
	Engines 615.912/941, 616, 617	+0.50 to +0.90

Note

Prior to refacing, be sure to check piston projection. This must not exceed 0.9 and 1.05 mm, respectively (03—316).

After refacing, be sure to chamfer cylinder bores.

If crankcase parting surface has been refaced, valve timing will need re-adjusting (05—215).

